

Work Order ID 69831

Thursday, May 19, 2011 3:18:09 PM



Page 1

Item ID: D4037-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Crossbeam

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-05-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4037

C L/R

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4037-1_BLANK

11-5-25



6/6/11, Y 10

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA877 AND DWG

FOLIO REV: AA

DWG REV: D

SL 11/06/06



DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69831

Thursday, May 19, 2011 3:18:09 PM



Page 2

Item ID: D4037-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Crossbeam

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/06/06

2

Ø



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

BA 11/06/06

2

Ø



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

2 Ø BR 11-6-6.



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69831

Thursday, May 19, 2011 3:18:09 PM



Page 3

Item ID: D4037-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Crossbeam

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START:
QUENT:
FINISH:

0.00

19:15
320 OF
9:452x ~~φ~~ M-φ 4/06/07

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2 ~~φ~~ M-φ 4/06/07

170



Packaging

Packaging

Identify as per dwg & Stock Location: 187

0.00

Memo

0.00

1B ~~φ~~ 11/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


Work Order ID 69831

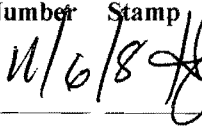
Thursday, May 19, 2011 3:18:09 PM

Page 4

Item ID: D4037-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Aft Crossbeam
Start Date: 5/20/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 6/3/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/6/8 
CLU106108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 3:18:05 PM

Page 1

Work Order ID: 69831



Parent Item: D4037-1



Parent Item Name: Aft Crossbeam

Start Date: 5/20/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC IPP REV
C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	39.0000	3.9	8.210526			



6061-T6 Bar 1.00 x 15.00



11-5-25

Location

Loc Qty

Loc Code

MAT005

39

115173

12

117372

24

9544

3

117352

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 69831
Description: Aft Crossbeam		Part Number: D4037-1
Inspection Dwg: D4037	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.530	+/-0.010	0.521	✓		t-gauge + vern	SL-3
0.25	+/-0.030	0.256	✓		mic 118-120	
2.00	+/-0.030	2.007	✓		t-gauge + vern	SL-3
2.75	+/-0.030	2.752	✓		vern SL-3	
1.00	+/-0.030	0.989	✓			
R0.032	+/-0.010	0.032	✓			
42.87	+/-0.030	42.875	✓		mic type	
1.38	+/-0.030	1.379	✓		vern SL-3	
1.750	+/-0.010	1.750	✓			
2.125	+/-0.010	2.125	✓			
2.250	+/-0.010	2.250	✓			
0.875	+/-0.010	0.873	✓			
0.875	+/-0.010	0.873	✓			
6.000	+/-0.010	6.000	✓			
1.125	+/-0.010	1.125	✓			
0.86	+/-0.030	0.859	✓			
1.38	+/-0.030	1.377	✓			
1.38	+/-0.030					
8.04	+/-0.030	8.045	✓		vern CN-02	
5.29	+/-0.030	5.292	✓		H-G	
6.00	+/-0.030	6.00	✓			
Ø0.316	+0.006/-0.001	0.317	✓			
Ø0.391	+0.006/-0.001	0.392	✓			

Measured by: JL	Audited by: B.A	Preliminary Approval:
Date: 11/06/02	Date: 11/06/06	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	

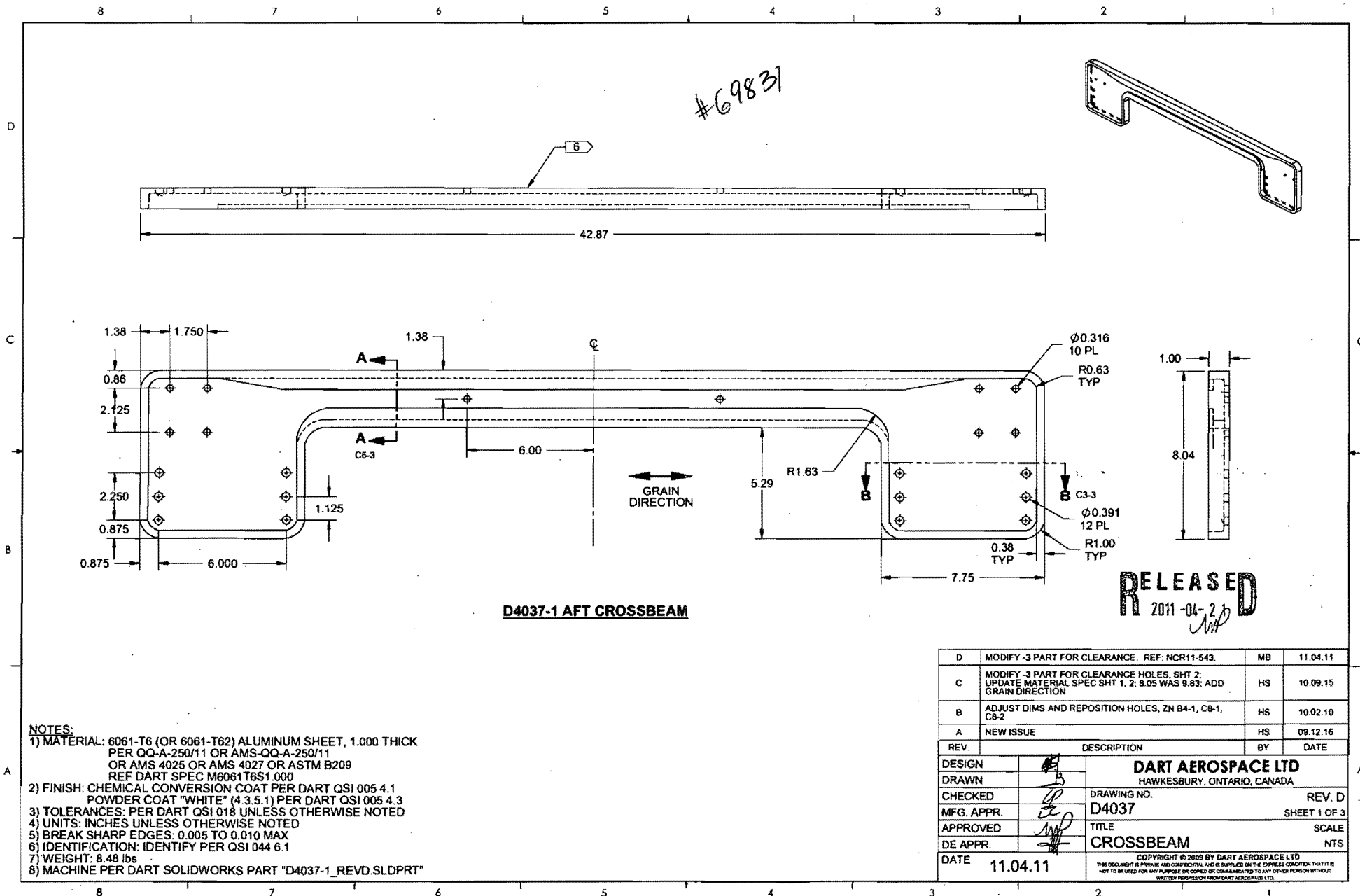
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

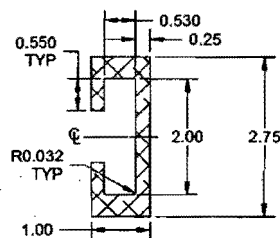
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

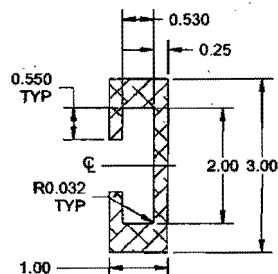
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

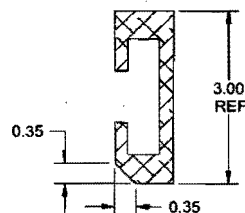




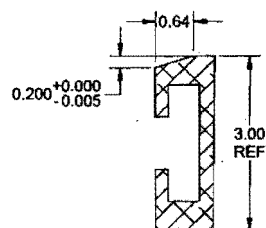
SECTION A-A B6-1
SCALE 2X



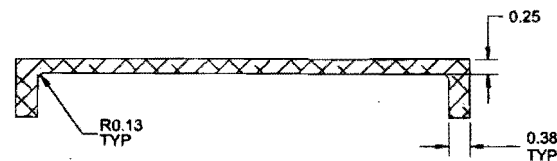
SECTION C-C B6-2
SCALE 2X



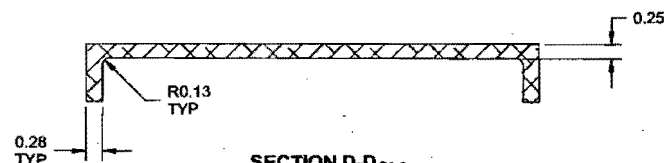
SECTION E-E C5-2
SCALE 2X



SECTION F-F B5-2
SCALE 2X



SECTION B-B B2-1
SCALE 2X



SECTION D-D B3-2
SCALE 2X

RELEASED
2011-04-31
JN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4037	REV. D
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		CROSSBEAM	SCALE
DE APPR.			NTS
DATE	11.04.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED OR COPIED OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

